

Date: Thursday, 7/12/2007 10:46:19 AM  
User: Kim Johnston

# Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : GAS SPRING
Job Number : 33521	
Estimate Number : 12941	
P.O. Number : N/A	Part Number : D355211
This Issue : 7/12/2007 S.O. No. : N/A	Drawing Number : D3552 REV C
Prsht Rev. : NC	Project Number : N/A
First Issue : 7/12/2007 Type : PURCHASED PARTS	Drawing Revision : C
Previous Run : N/A	Material : N/A
Written By : <u>[Signature]</u>	Due Date : 7/17/2007 Qty: 4 Um: Each
Checked & Approved By : <u>[Signature] 07.07.12</u>	
Comment : Est Rev: A New Issue 06-11-13 EC	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PG	PURCHASING
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Comment: Issue P/O: 4159 07/07/12  
Purchase Part Number: B8-240-575-150N  
Supplier: LS Technologies  
Certificate of conformity is required

(4)

2.0	B8 240 575 150N	CARBON STEEL GAS SPRING
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)  
CARBON STEEL GAS SPRING

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1  
Receive & Inspect For Transit Damage  
Ensure certificate of conformity is attached

07/07/13 (4)

4.0	QC6	DIMENSIONAL CHECK
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Comment: DIMENSIONAL CHECK

Test for correct pressure

Tested su for pressure  
07/07/12 (4)

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1  
Identify and Stock  
Location: \_\_\_\_\_

7/7/17 SP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes (No) DQA: L-7 Date: 07/07/23  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GAS SPRING

Job Number: 33521

Part Number: D355211

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



07.07.17 *[Signature]*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



*[Signature]* 7-5-17

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

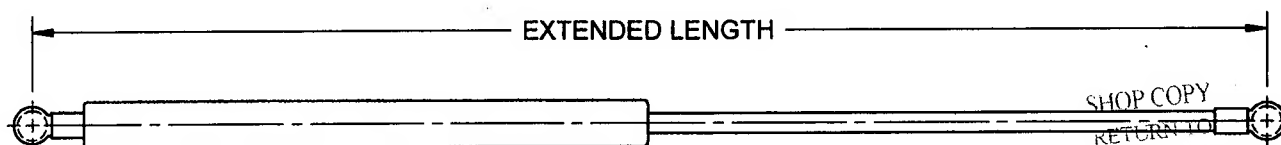
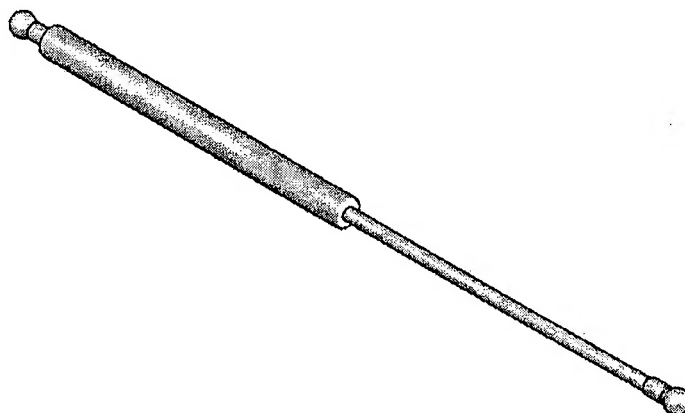
NOTE: Date & initial all entries



DESIGN <i>LE</i>	DRAWN BY <i>LE</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>B</i>	APPROVED <i>TH</i>	DRAWING NO. <b>D3552</b>	REV. C SHEET 1 OF 1
DATE <b>07.06.01</b>		TITLE <b>GAS SPRING</b> SCALE NTS	
REV	DATE	DESCRIPTION	
A	06.09.15	NEW ISSUE	
B	06.10.24	ADD D3552-7/-9; UPDATE DESC. D3552-1/-3/-5	
C	07.06.01	ADD D3552-11 AND CONVERSIONS FOR INSPECTION; UPDATE P/N FOR D3552-7	

**RELEASED**  
07.07.11  
PER BAW #1009

## SPECIFICATION CONTROL DRAWING



### D3552-X GAS SPRING

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER

DART P/N	STROKE (mm/in)	EXTENDED LENGTH (mm/in)	FORCE (N/lb)	END FITTING	MATERIAL	LS TECHNOLOGIES P/N
D3552-1	220/8.66	530/20.6	70/15.7	10mm SS BALL SOCKET	CARBON STEEL	C8-220-530-070N
D3552-3	200/7.87	490/19.3	200/45.0	10mm SS BALL SOCKET	CARBON STEEL	C8-200-490-200N
D3552-5	175/6.89	430/16.9	150/33.7	10mm SS BALL SOCKET	CARBON STEEL	C8-175-430-150N
D3552-7	220/8.66	530/20.9	70/15.7	10mm NYLON BALL SOCKET	CARBON STEEL	B6-220-530-070N
D3552-9	200/7.87	490/19.3	200/45.0	10mm NYLON BALL SOCKET	CARBON STEEL	B8-200-490-200N
D3552-11	240/9.45	575/22.6	150/33.7	10mm NYLON BALL SOCKET	CARBON STEEL	B8-240-575-150N

**NOTE:**

- 1) IDENTIFY WITH DART P/N "D3552-X" USING WHITE FINE POINT PERMANENT INK MARKER

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## Certificate of Compliance

This is to certify that the parts listed below meets specifications as required by your order.

**4 Units: B8-240-575-150N Carbon Steel Gas Spring**

**Country of Manufacture : Canada**

**This product is ROHS compliant.**

**We certify no mercury was used in the manufacture of this order.**

Purchase Order # 4159  
Invoice # 3780

L S Technologies Inc Canada

A handwritten signature in black ink, appearing to be "Nolan Fehr", written over a horizontal line.

Nolan Fehr  
Manager

